



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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006726

646.4001

Job Sheet 185751



Part No: 646.4001

Job Qty: 1 ea

Part Name: AS350 Cable Cutter System



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/1/18

Job Tracking No:

Due Date: 12/14/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C1 IPP REV:A 12.10.23 NEW ISSUE DD VERF:JLM IPP REV:B 15.01.08 AS PER DWG REV.B DD VERF:JLM IPP REV:C 16.01.07 AS PER DWG REV.C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	12/14/18	12/14/18	0.00	0.00	Start Up Stores/Pkg-1		NOV 28 2018
110	Packaging	1 pcs	12/14/18	12/14/18	0.00	0.00	Packaging1-1		JAN 15 2019
120	QC	1 pcs	12/14/18	12/14/18	0.00	0.00	QC4		JAN 15 2019
130	Packaging	1 pcs	12/14/18	12/14/18	0.00	0.00	Packaging3-1		JAN 15 2019
135	DC	1 pcs	12/14/18	12/14/18	0.00	0.00	DC		JAN 15 2019
140	QC21-FG	1 Ea	12/14/18	12/14/18	0.00	0.00	QC21		JAN 15 2019

Part Op 130 - Identify and pack for shipping as per PPP 646.4001 Location: _____
Descriptions: 135 - Photocopy bluefile & type labels per PPP 646.4001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
600.0129	VHB Tape	8 ft (8 ea)	90-Start up Operation	5019004
600.0990	Magnabond 6398 Part A Size 112 ml	1 Ea (1 ea)	90-Start up Operation	5136925
600.0991	Magnabond 6398 Part B Size 112 ml	1 Ea (1 ea)	90-Start up Operation	5136931
600.1012	Sealant PR1425B2 (#654 sem)	1 pcs (1 ea)	90-Start up Operation	5130299
600.1013	021200-3M Tape Primer 94 Primer 24216	5 Ea (5 ea)	90-Start up Operation	5119441
646.2910	Deflector	1 Ea (1 ea)	90-Start up Operation	5079498
646.3001	Lower Cable Cutter Assembly	1 Ea (1 ea)	90-Start up Operation	5125414
646.3110	Channel	1 Ea (1 ea)	90-Start up Operation	5136495
646.3210	Support	1 Ea (1 ea)	90-Start up Operation	5091495
646.3301	Upper Cutter Assembly	1 Ea (1 ea)	90-Start up Operation	5083327
646.3510	Strut	1 Ea (1 ea)	90-Start up Operation	5081641
646.3511	Strut	1 Ea (1 ea)	90-Start up Operation	5063686
646.3610	Filler	1 Ea (1 ea)	90-Start up Operation	5072241
646.3710	Doubler	1 Ea (1 ea)	90-Start up Operation	5049669
646.3711	Clip	1 Ea (1 ea)	90-Start up Operation	5062766
646.3712	Clip	1 Ea (1 ea)	90-Start up Operation	508797
646.3713	Gusset	1 Ea (1 ea)	90-Start up Operation	5042029
646.3714	Gusset	1 Ea (1 ea)	90-Start up Operation	5038824
646.3715	Strut Doubler	2 Ea (2 ea)	90-Start up Operation	5082442
646.3716	Gauge Bracket	1 Ea (1 ea)	90-Start up Operation	5062780
646.3717	Doubler	1 Ea (1 ea)	90-Start up Operation	5038801
646.3718	Custom Washer	2 Ea (2 ea)	90-Start up Operation	5064802

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐	AGAINST DEPARTMENT/PROCESS					
		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Composite ☐	Supplier ☐				

Date : _____

Step #: _____

MRB (QSI042) Approval

Description Work Order D

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: T 613 632-6200
Email: sales@dartaero.com
www.dartaerospace.com



Container No: S137033

Part: 646.4001

Job No: 185751

Serial No/Batch: S137033

Revision:

Inspector:

Exp Date: 05/11/2019

Instructions: FAA STC SR02180LA 14/08/07/16 STC SH09

Completed By

Lead hand / Supervisor
Approval Verification

QC / QA Coordinator
Approval

Root Cause

Environment ☐	No Re-verification ☐	Bending ☐	BOIM/rouge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Centre Not Concentric ☐	Broken/Damage/Defect ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Cracks ☐	Inspection Incomplete/Unqualified ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Crimp/Kink/Ripple/Wave ☐	Contamination ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Cuffs ☐	Wrong Stock Pulley ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Crushing ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Heat Treat ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Wave/Twist in Tube ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Marks/Chatter ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐		Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐			
Misidentified ☐	Past Due ☐	OTHER: ☐		

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646.3719	Doubler	2 Ea (2 ea)	90-Start up Operation
646.3810	Bracket	2 Ea (2 ea)	90-Start up Operation
646.3811	Radius Block	1 Ea (1 ea)	90-Start up Operation
646.3812	Gusset Bracket	2 Ea (2 ea)	90-Start up Operation
646.3813	AS350 Strut Bracket	1 Ea (1 ea)	90-Start up Operation
646.3910	Shim	4 Ea (4 ea)	90-Start up Operation
646.3911	Shim	1 Ea (1 ea)	90-Start up Operation
646.3912	Shim	4 Ea (4 ea)	90-Start up Operation
646.3913	Shim	1 Ea (1 ea)	90-Start up Operation
646.9410	Shim	1 Ea (1 ea)	90-Start up Operation
647.0112	Strut Bracket	2 Ea (2 ea)	90-Start up Operation
647.7703	Strut Assembly	2 Ea (2 ea)	90-Start up Operation
650.9201	Eyelet Bracket Assembly	2 Ea (2 ea)	90-Start up Operation
AN3-11A	Bolt	10 Ea (10 ea)	90-Start up Operation
AN3-12A	Bolt	2 Ea (2 ea)	90-Start up Operation
AN3-13A	Bolt	1 Ea (1 ea)	90-Start up Operation
AN3-3A	Bolt	4 Ea (4 ea)	90-Start up Operation
AN3-4A	Bolt	10 Ea (10 ea)	90-Start up Operation
AN3-5A	Bolt	2 Ea (2 ea)	90-Start up Operation
AN3-6A	Bolt	2 Ea (2 ea)	90-Start up Operation
AN316C4R	Nut, Jam	2 Ea (2 ea)	90-Start up Operation
AN44-5A	Eyebolt	2 Ea (2 ea)	90-Start up Operation
AN4C7A	Bolt	2 Ea (2 ea)	90-Start up Operation
AN665-34R	Clevis	2 Ea (2 ea)	90-Start up Operation
CCR264SS3-02	Cherry Rivet	36 Ea (36 ea)	90-Start up Operation
CR3213-5-3	Cherry Rivet	14 Ea (14 ea)	90-Start up Operation
MS20426AD5-7	Rivet	2 Ea (2 ea)	90-Start up Operation
MS20470AD5-5.5	Rivet	8 Ea (8 ea)	90-Start up Operation
MS20470AD5-6	Rivet	8 Ea (8 ea)	90-Start up Operation
MS20470AD5-7	Rivet	3 Ea (3 ea)	90-Start up Operation
MS21042L08	Nut	2 Ea (2 ea)	90-Start up Operation
MS21042L3	Nut	63 Ea (63 ea)	90-Start up Operation
MS21042L4	Nut	2 Ea (2 ea)	90-Start up Operation
MS21047-3	Nut Plate	18 Ea (18 ea)	90-Start up Operation
MS24693-C278	Screw	5 Ea (5 ea)	90-Start up Operation
MS24694-S51	Screw	5 Ea (5 ea)	90-Start up Operation
MS24694-S54	Screw	2 Ea (2 ea)	90-Start up Operation
MS24694-S55	Screw	3 Ea (3 ea)	90-Start up Operation
MS27039-08-13	Screw	2 Ea (2 ea)	90-Start up Operation
MS27039-1-10	Screw	2 Ea (2 ea)	90-Start up Operation
MS27039-1-12	Screw	6 Ea (6 ea)	90-Start up Operation
MS27039-1-16	Screw	24 Ea (24 ea)	90-Start up Operation
MS27039-1-19	Screw	22 Ea (22 ea)	90-Start up Operation
MS27039-1-20	Screw	2 Ea (2 ea)	90-Start up Operation
MS27039-1-21	Screw	4 Ea (4 ea)	90-Start up Operation
NAS1149F0332P	Washer	144 Ea (144 ea)	90-Start up Operation
NAS1149F0363P	Washer	2 Ea (2 ea)	90-Start up Operation
NAS1149F0432P	Washer	4 Ea (4 ea)	90-Start up Operation
NAS1149FN832P	Washer	4 Ea (4 ea)	90-Start up Operation

5063754
 5131074
 3070843
 5131076
 5073258
 5124277
 3041250
 5128109
 5041498
 5056998
 5097197
 5128424
 8122789
 5130322
 5095479
 5098032
 5131193
 5112901
 5119258
 5103950
 5080637
 5104032
 5095478
 5131214
 5103962
 5108575
 5153848
 51134063
 5124089
 5123425
 5100409
 5094592
 5109736
 5103943
 5065341
 5004859
 5118346
 5099526
 5016508
 5071834
 5006971
 5104364
 5131198
 5094554
 5104041
 5131201
 5075330
 5123450
 5107796

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	600.0129	8	264	0
	600.0990	1	15	0
	600.0991	1	13	0
	600.1012	1	26	0
	600.1013	5	74	0
	646.2910	1	25	0
	646.3001	1	8	0
	646.3110	1	12	0
	646.3210	1	14	0
	646.3301	1	12	0
	646.3510	1	17	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

646.3511	1	22	0
646.3610	1	22	0
646.3710	1	48	0
646.3711	1	32	0
646.3712	1	20	0
646.3713	1	15	0
646.3714	1	21	0
646.3715	2	29	0
646.3716	1	38	0
646.3717	1	24	0
646.3718	2	40	0
646.3719	2	32	0
646.3810	2	19	0
646.3811	1	29	0
646.3812	2	14	0
646.3813	1	11	0
646.3910	4	35	0
646.3911	1	21	0
646.3912	4	32	0
646.3913	1	37	0
646.9410	1	99	0
647.0112	2	84	0
647.7703	2	16	0
650.9201	2	33	0
AN3-11A	10	155	0
AN3-12A	2	92	0
AN3-13A	1	97	0
AN3-3A	4	206	0
AN3-4A	10	366	0
AN3-5A	2	322	0
AN3-6A	2	196	0
AN316C4R	2	35	0
AN44-5A	2	29	0
AN4C7A	2	141	0
AN665-34R	2	27	0
CCR264SS3-02	36	599	0
CR3213-5-3	14	260	0
MS20426AD5-7	2	1,014	0
MS20470AD5-5.5	8	234	0
MS20470AD5-6	8	1,017	0
MS20470AD5-7	3	140	0
MS21042L08	2	1,956	0
MS21042L3	63	2,260	0
MS21042L4	2	3,367	0
MS21047-3	18	472	0
MS24693-C278	5	144	0
MS24694-S51	5	300	0
MS24694-S54	2	408	0
MS24694-S55	3	101	0
MS27039-08-13	2	80	0
MS27039-1-10	2	137	0
MS27039-1-12	6	85	0
MS27039-1-16	24	597	0
MS27039-1-19	22	351	0
MS27039-1-20	2	105	0
MS27039-1-21	4	114	0
NAS1149F0332P	144	2,061	0
NAS1149F0363P	2	562	0
NAS1149F0432P	4	1,422	0
NAS1149FN832P	4	2,779	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
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OTHER :					

